

# Work Order ID 77498

December-09-11 7:59:28 AM

**\*77498\***

Page 1

Item ID: D3282-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Float Web (206L/407)

Start Date: 09/12/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 06/01/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/09

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3282	D								

100

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.  
2- inspect for surface damage as per QSI0018  
3- Deburr

*GF* 11/12-09  
*DP*

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282  
2-Deburr

*2- 12 . 1 . 2*  
*OK*

*10*

120

0.00

QC2- Inspect parts off machine FAI/FAIB

**\*120\***

QC

Memo

0.00

Quality Control

*2- 12 . 1 . 2*  
*OK*

*10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3282-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
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Start Date: 09/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 06/01/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		SL 12-01-03					
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				10		SAD 12-01-05	
150 <b>*150*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							DP 12-1-5 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 77498

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**\*77498\***

Page 3

Item ID: D3282-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Float Web (206L/407)  
 Start Date: 09/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 06/01/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
<b>*160*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Install doublers as per Dwg D3282.								
						(10)	Ø	CF	12-1-19
								SAD	
170	QC5- Inspect part completeness to step on W/O	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
									8/12/01/19
180	Identify as per dwg & Stock Location: <del>6009</del> LG	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging									
						10		SAD	12-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 77498****\*77498\***

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Revision ID:

Item Name: Float Web (206L/407)

Stop **\*NS2\***

Start Date: 09/12/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 06/01/2012 Req'd Qty: 10.00

**\*10\***


Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

12/1/23   
R1201-20  
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

December-09-11 7:59:33 AM

Page 1

Work Order ID: 77498

**\*77498\***

Parent Item: D3282-041

**\*D3282-041\***

Parent Item Name: Float Web (206L/407)

Start Date: 09/12/2011

Required Date: 06/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM  
remove LPS as per dwg revD DD verf:JLM  
IPP REV:C 11.09.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130 <b>*D2792-130*</b> EXTRUSIONS		Manufactured	No			100	Each	51.0000	1	10			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		51							
				72839		51							
D3283-1 <b>*D3283-1*</b> Doublor		Manufactured	No			160	Each	41.0000	2	10			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST045		41							
				73611		5							
				74314		36							
MS20470AD4-7 <b>*MS20470AD4-7*</b> Rivet, Universal Head		Purchased	No			160	Each	1,494.000	57	570			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST320		1494							
				116081		117							
				117887		269							
				118614		1108							

C# / DP 11-12-09

20  
570  
C# / K 12-01-05

570  
C# / 12-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	77496
<b>Description:</b> Float Web		<b>Part Number:</b>	D3282-041
<b>Inspection Dwg:</b> D3282	<b>Rev:</b> <i>11.12.09</i>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.62	/		29.14	
1.500	+/-0.010	1.500	/		29.02	
3.000	+/-0.010	3.000	/		29.15	
6.000	+/-0.010	6.500	/			
1.250	+/-0.010	1.250	/			
30.000	+/-0.010	30.000	/			
1.500	+/-0.010	1.500	/			
72.01	+/-0.030	72.01	/			
61.75	+/-0.030	61.78	/			
57.50	+/-0.030	57.50	/			
49.19	+/-0.030	49.19	/			
43.94	+/-0.030	43.94	/			
39.69	+/-0.030	39.69	/			
26.68	+/-0.030	26.68	/			
0.55	+/-0.030	.546	/			
1.970	+/-0.010	1.970	/			
2.38	+/-0.030	2.377	/			
0.05	+/-0.030	.044	/			

<b>Measured by:</b> <i>29</i>	<b>Audited by:</b> <i>JL</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12.1.2	<b>Date:</b> 12-01-03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

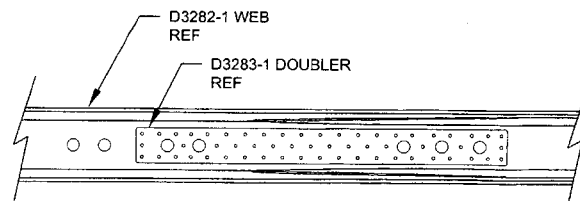
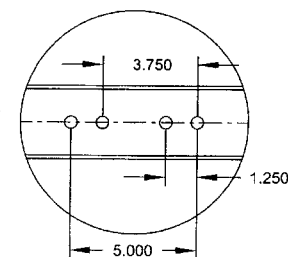
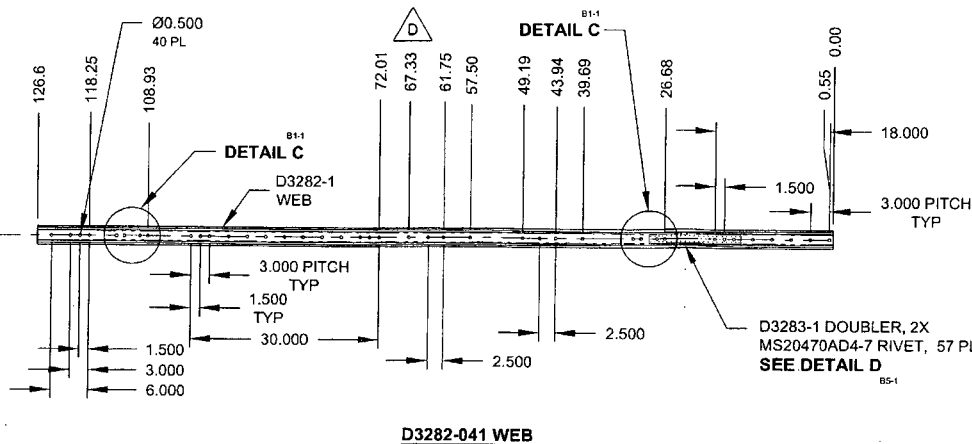
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL D  
D4-1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37498 M.L.J.  
11/12/05

NOTE: RIVET HOLES/DOUBLER  
NOT SHOWN FOR CLARITY

DETAIL C  
D5-1  
D6-1

RELEASED  
2011-09-12

NOTES:

- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	JP		
MFG. APPR.	BE		
APPROVED	JP		
DE APPR.	JP	DRAWING NO.	REV.
		D3282	SHEET 1 OF 2
		TITLE	SCALE
		WEB	NT
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

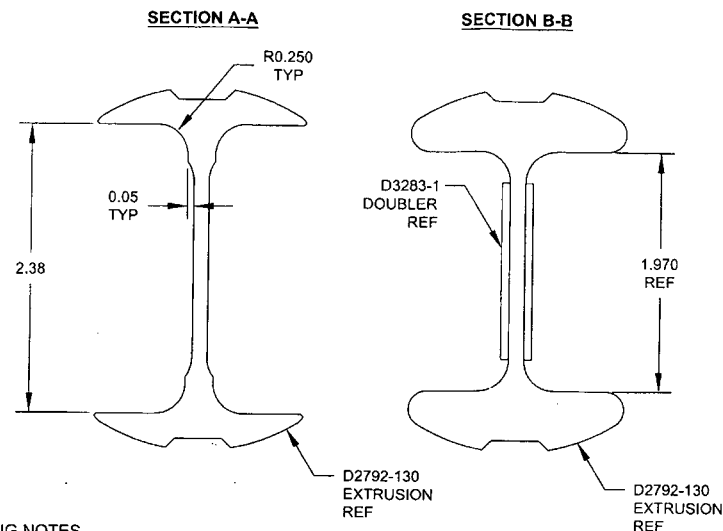
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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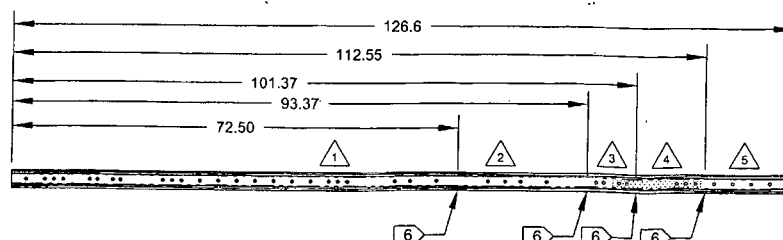
**NOTE:** Date & initial all entries

77498



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



**RELEASED**  
2011-09-12

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	EE	D3282	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.		WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONVICTION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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